

Date: Monday, 27/04/2009 2:30:07 PM
 User: Linda Lacelle

Process Sheet

AOG Split

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM	
Job Number	: 47553			Part Number	: D2066	
Estimate Number	: 12172			Drawing Number	: D2066 REV C	
P.O. Number	:			Project Number	: N/A	
This Issue	: 27/04/2009	S.O. No.	:	Drawing Revision	: C	
Prsht Rev.	: NC			Material	:	
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 28/04/2009	
Previous Run	: 34919			Qty:	2	Um: Each
Written By	:					
Checked & Approved By	:					
Comment	: Est. D 02.03.18 Added pick list NG est E 07.10.03 removed p/c EC verified by: DD Est Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2052	Mounting Bracket	(2)
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bracket batch: B 39556	
2.0	D2054	Bushing	FF 09-04-28
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing - Delrin batch: B 39433	
3.0	D2055	Clamp	FF 09-04-28 (2)
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clamp batch: R 34365	
4.0	D2056	Bell Crank	FF 09-04-28 (2)
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bell Crank Assembly batch: B 39434	

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Part Number: D2066

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M110985

FF 09-04-28

(2)

6.0 MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

batch: M110844

FF 09-04-28

(2)

7.0 MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

batch: M108161

FF 09-04-28

(2)

8.0 M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 2.5053 f(s)/Unit Total : 12.5265 f(s)

304 RD Tube .500 x .049W

304/316 SS Seamless Tube

batch: m110968

FF 09-04-28

(2)

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1/2" OD x .035" Wall 304/316 SS Seamless Tube

(Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)

Use punch Jig DT8012

2-Slide on parts per Dwg and W/O for D2676-043

3-Punch other end to length (28.62") as per Dwg D2066

4-Bend per Dwg D2066

5-Drill 3/16" (0.188") Dia holes per Dwg D2066 using drill jig DT9034
and template AT8054

FF 09-04-28

(2)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Polish and Deburr

7- assemble parts as per dwg D2066

FF09-04-28

(2)

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/09/04/28 (2)

(2x)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/04/28

SQ

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

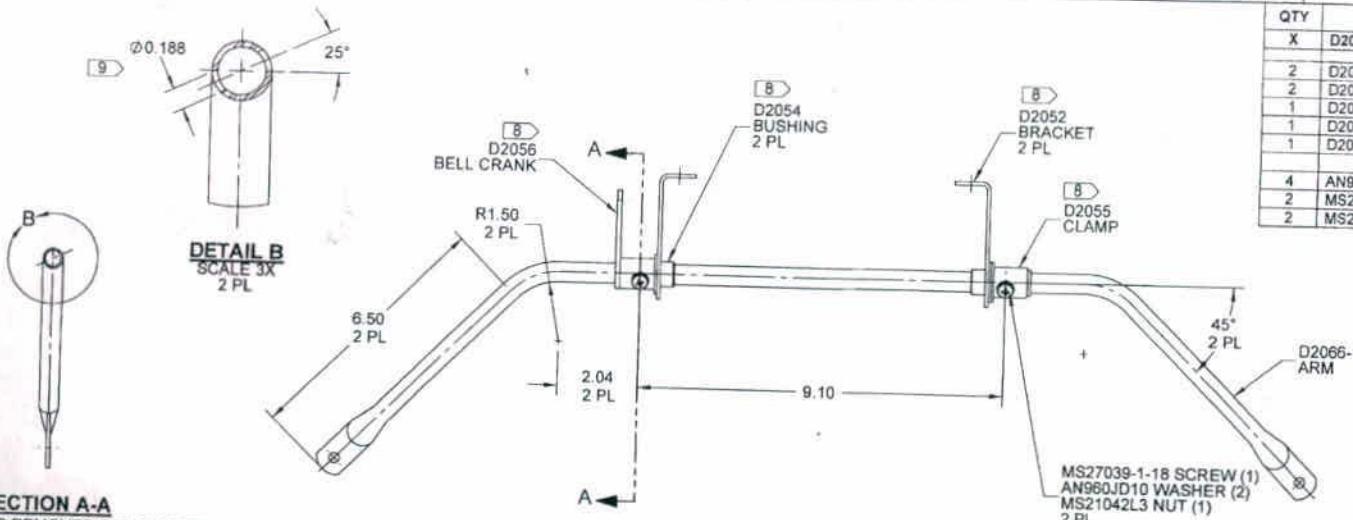
09/04/28 (2)

Job Completion



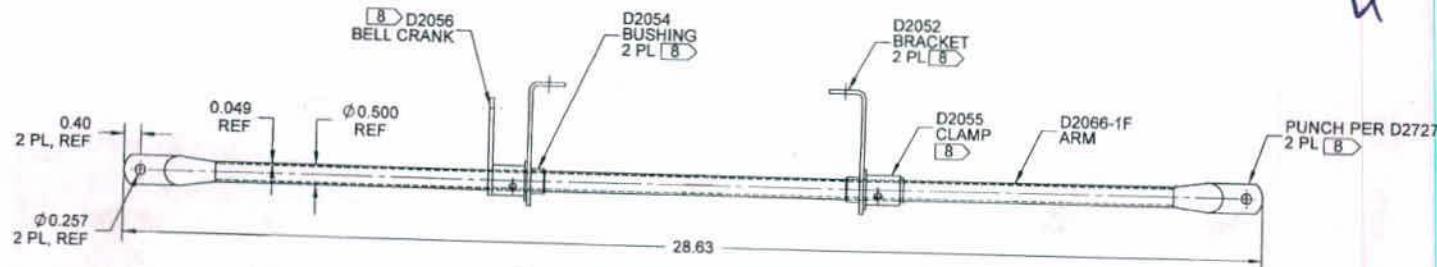
6/09-04-28

QTY	P/N	DESCRIPTION
X	D2066	ARM
2	D2052	BRACKET
2	D2054	BUSHING
1	D2055	CLAMP
1	D2056	BELL CRANK
1	D2066-1	ARM
4	AN960JD10	WASHER
2	MS21042L3	NUT
2	MS27039-1-18	SCREW



SECTION A-A
(SOME PARTS REMOVED FOR CLARITY)

D2066-1 ARM BENDING DETAIL
(MAKE FROM D2066-1F)



D2066-1F ARM CUT LENGTH DETAIL

RELEASED
08-07-23-10

NOTES:

- 1) MATERIAL: D2066-1F: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø 0.500 X 0.049 WALL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2066-1 = 0.62 lbs (SEE SHEET 1 FOR ASSEMBLY WEIGHT)
- 8) BEFORE BENDING: ADD D2052 BRACKETS, D2054 BUSHINGS, D2055 CLAMP AND D2056 BELL CRANK TO D2066-1 ARM
AFTER FIRST END OF D2066-1 IS PUNCHED AND BEFORE SECOND END OF D2066-1 IS PUNCHED
- 9) DRILL Ø 0.188 AFTER BENDING

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	D2066	
APPROVED	<i>[Signature]</i>	REV. C	
DE APPR.	<i>[Signature]</i>	TITLE	
DATE	08.06.12	SHEET 2 OF 2	
NTS			

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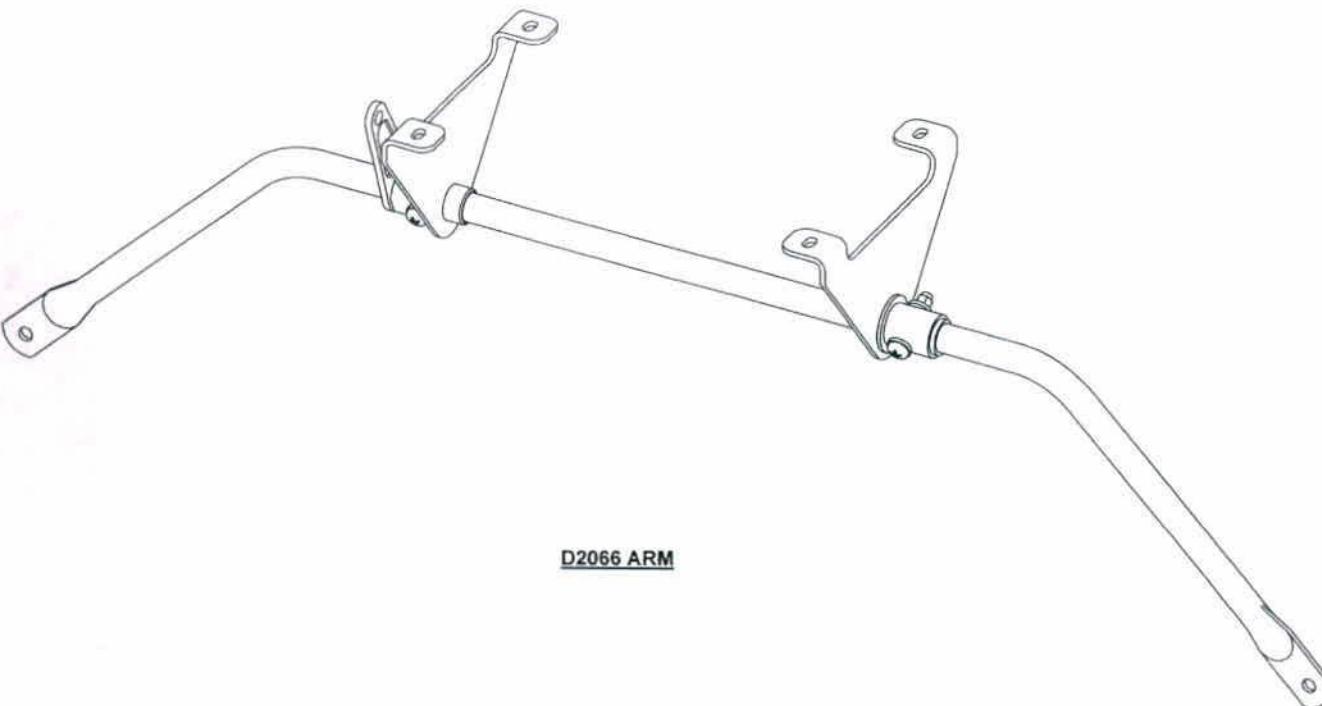
C

B

B

A

A



X7557

RELEASED
09-07-13

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.85 lbs

C	REDESIGNED	PH	08.06.12
B	RE-DESIGNED	BW	06.02.06
A	NEW ISSUE	BW	02.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	P&E	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	REV. C	
MFG. APPR.	P&E	DRAWING NO.	D2066
APPROVED	M&P	SHEET 1 OF 2	
DE APPR.	H&H	TITLE	ARM
DATE	08.06.12	SCALE	NTS

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3.0 CARGO MIRROR INSTALLATION

Install the Cargo Mirror as follows:

1. Install D206-558-041/-043 cargo mirror assembly using AN3-4A bolts and AN960JD10L washers. Pickup existing anchor nuts in 4 places.
2. Install D2067 connector onto D2056 bellcrank assembly to locate hole for MS35489-9 grommet. With the mirror in the deployed position, mark and drill $\varnothing 0.125"$ (3.2mm) hole in landing light window panel where the grommet should be located. Open pilot hole to $\varnothing 0.563"$ (14.3mm). Install grommet.
3. Install D2053 bracket using AN526-1032R9 screws. Pickup on existing anchor nuts.
4. Position D2071 cable as shown. Install MS21919DG5 clamps using AN526-1032R9 screws where required. Pickup existing rivnuts or anchor nuts if available.
5. Install D2071 control cable using D2067 connector. Connector should rotate freely in bellcrank when MS21042-3 nut is torqued and cable clamped

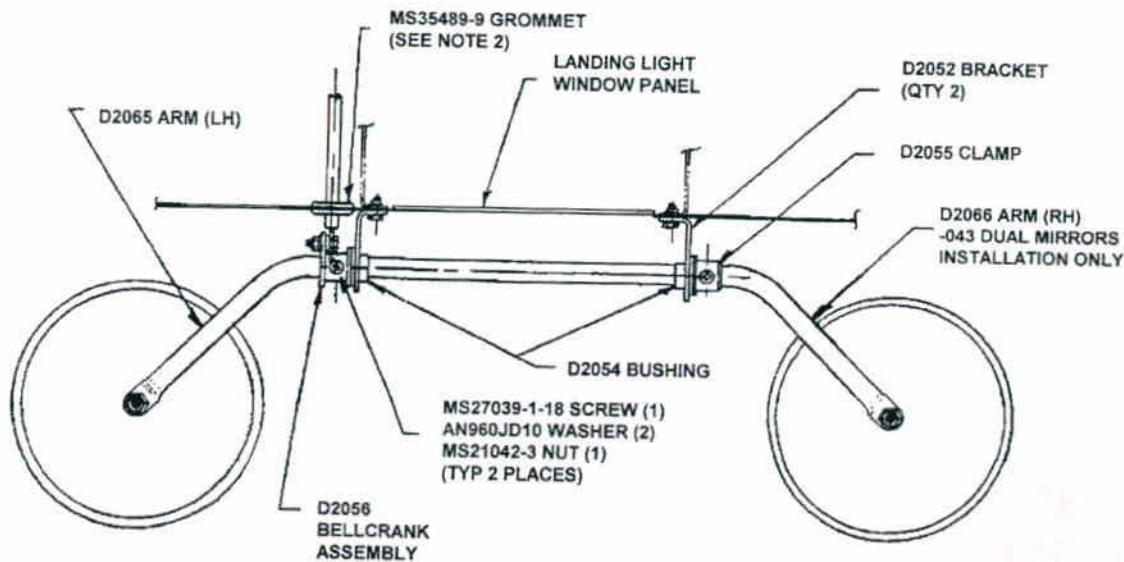


Figure 2: – View A: Looking Aft.
(D206-558-043 Mirror Shown)